Think threads with YAMAWA

No.045

How to use coolant through taps

Cutting Taps

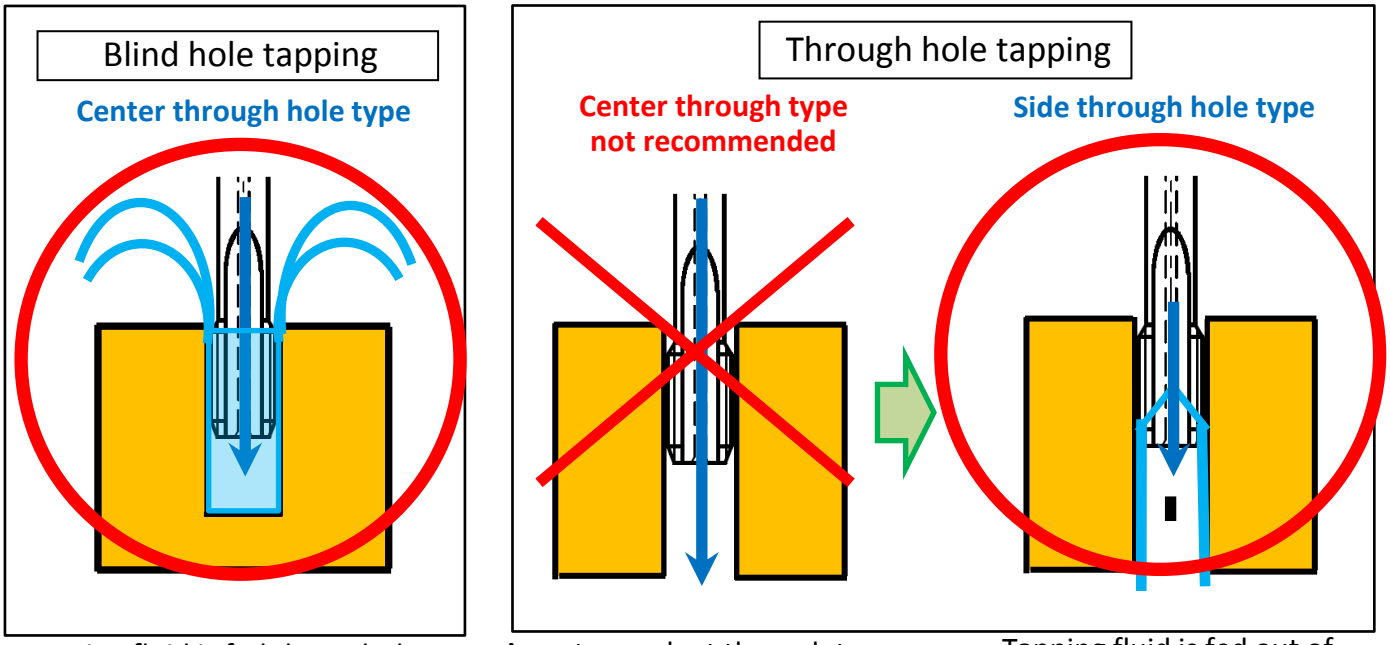
【Question】

Coolant through taps are categorized by the way the coolant goes though the center of the tap or out the side of the tap.
Which type of coolant through tap should I use?

【Answer】

Coolant through taps can be selected by determining if the application is for through hole tapping or blind hole tapping.

【Guide】 The correct use of the center flow coolant though taps and side port coolant through taps.



Tapping fluid is fed through the center hole of the tap and comes out the end at the bottom of the bored hole. The coolant is forced back out of the hole over the flutes. As a result, the tapping fluid is supplied to the taps cutting chamfered threads and the entire surface of the bored hole is lubricated.

A center coolant through tap feeds the tapping fluid through the center hole and will not contact the bored hole in a through hole application. The tap is not supplying the tapping fluid to the taps cutting chamfer as it runs out the end of the bored hole.

Tapping fluid is fed out of the side port of the tap for through hole tapping applications. The side coolant port supplies fluid to the taps cutting chamfer threads while lubricating the internal surface of the bored hole.

【Advice】

Look for the tapping application icons printed in the Yamawa catalogs and leaflets to help determine the type of coolant through tap needed for your application.

for through hole tapping

for blind hole tapping